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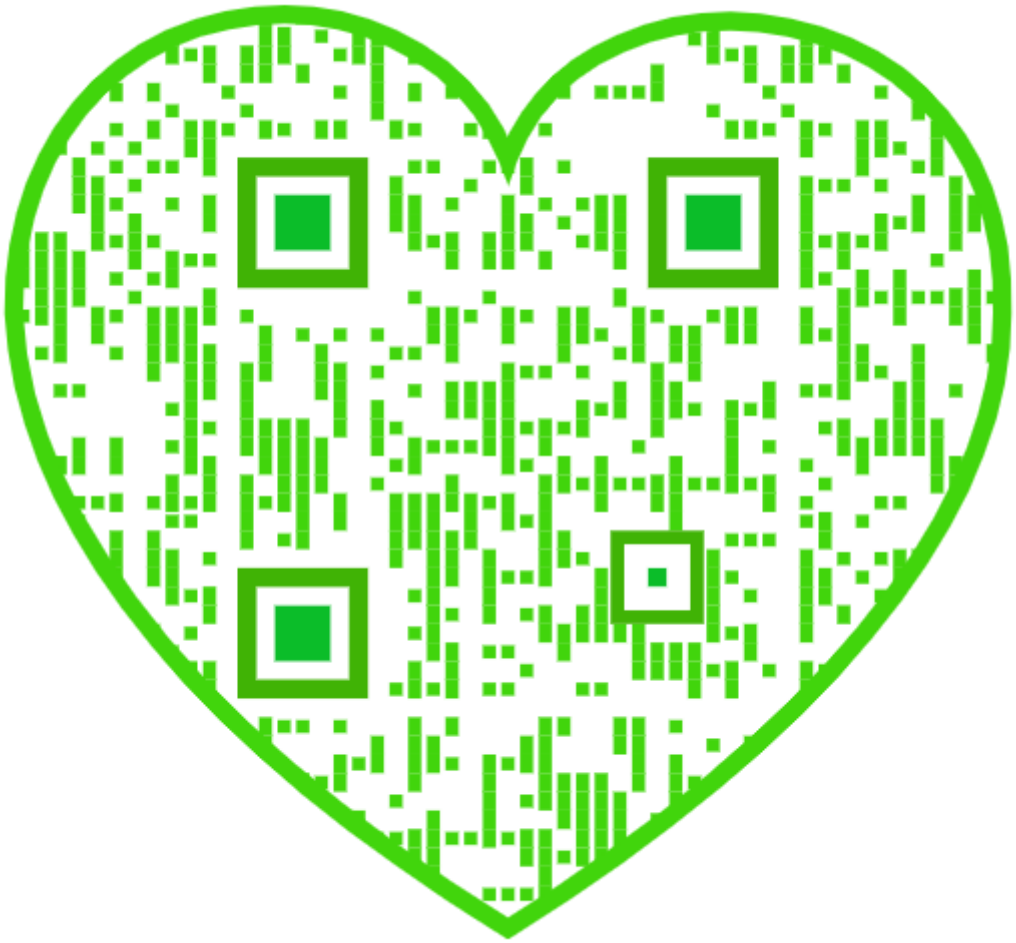

. . . . THE . . . .

Finisher's Manual.

Containing the Recipts of an Expert for Finishing the Bottoms of Boots and Shoe, as well as Other Valuable Information . . . . . .

FINISHER'S MANUAL PUBLISHING CO.,

82 Lincoln Street, Boston, Mass.

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Containing the Receipts of an Expert for Finishing the Bottoms of Boots and Shoes, as well as other valuable information.

PRICE, $2.00.

Finishers' Manual Publishing Co.

82 LINCOLN STREET,

BOSTON.

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PREFACE.

In issuing this book to the trade we give to the reader the results of many years of practical and successful experiments. We have made the finishing of hemlock leather a thorough study and we take pleasure in commending to your consideration our various formulas which will give a clear, even finish on any kind of leather provided our directions are strictly carried out. Every shoe manufacturer or finisher knows the value of a clean, bright attractive finish on his goods. The formulas we offer have been thoroughly and successfully tested by the best known manufacturers and finishers in this country. The finisher will do well to remember that it is the individual skill of the workman in performing many apparently simple operations which renders those operations successful. When, therefore, a receipt is tried for the first time and is not thoroughly successful, the experimentalist should consider how far his own inexperience has contributed to the failure before he condemns the receipt.

Enamel Stain.

Color: White. 1 gall.

Pure White Lead	8 lbs
French Yellow	4 oz
White Glue, dissolved in 1 pt. hot water	4 "
White Castile Soap dissolved in 1 qt. hot water	4 "
French Isinglass dissolved in 3 pts. hot water	15 sheets.

Make a paste of white lead and Fr. yellow by wetting up with clean cold water. Let stand twenty-four hours.

It should then be thoroughly ground through a paint mill. Glue, soap and isinglass should be turned together and thoroughly mixed with white lead and Fr. yellow. Strain through cheese cloth. If you wish add a small quantity of pure white glycerine. The white lead should be pure and the finest ground to be obtained. Do not have too much of this stain on hand, as age does not improve it.

The enamel can be made in any shade by the following ingredients: Fr. yellow, chrome yellow, orange chrome, red ochre, Venetian red, Brandon, red, brown ochre, umber, extract of white oak bark. See table for colors and shades. Add all colors to the white lead dry; wet and grind. Should the stain thicken by long standing reduce with a solution made by the above, glue, soap and isinglass.

The enamel is applied in the same manner as the Oakaline or Ivory Stain.

Stir freely from the bottom, then take out with a long-handled dipper a small amount, put in a shallow dish; dust off the bottom of the shoe by power brush. With a 2-inch camels'-hair brush apply the stain to the sole of the shoe, first across and then immediately the other way of the sole; *then let dry thoroughly.*

With a very fine piece of sandpaper go over the sole of the shoe two or three times to smooth it off.

Apply a coat gum brush very lightly to lay it on even. Let dry, then brush to a polish. For a high polish, polish on roll.

The camels'-hair brush should be kept in water when not in use, and should be washed out thoroughly two or three times a day.

Your success depends on keeping your dish and brushes clean.

Jersey stains, No. 27 and 29, added to enamel white; 1 quart of Jersey to 3 quarts of enamel gives a very fine shade.

No. 1.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: Oak shade. For hemlock leather. 5 gall.

DIRECTIONS.

With a sponge, or varnish brush, soak the

stain well into the leather; brush in well with a stiff hand brush until the leather is *thoroughly saturated.* Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

China Clay	2½ lbs.
Chalk	2 "
French Yellow	½ "
Oxalic Acid	¼ "
Sulphate of Zinc	½ "
Oil of Vitriol	¼ "
Sumac Berry ground	1½ "
White Oak Bark ground	2½ "
Coignet Glue	1 sheet.
Soft Soap	2 qts.
Gum Tragacanth	2 qts.

DIRECTIONS FOR MIXING.

First chalk and soft soap should be thoroughly mixed together, the soap to cut the talk. Add China clay and Fr. yellow. Stir well together, add zinc and oxalic acid. Put sumac berry in a bag, boil in five gallons of water three hours. Press dry, mix all together in this extract, boil one hour, add glue and oil of vitriol while boiling.

No. 3.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: Oak. For hemlock leather.	1 gall.
French Yellow	1 lb.
Cream Tartar	6 ozs.
White Vitriol	7 "
Blue "	7 "
Sugar of Lead	8 "
Alum ground	8 "
Oxalic Acid	1½ lbs.
Oak Bark	1 lb.
Quinciteron Bark	1 "
Gum Tragacanth	1 qt.

DIRECTIONS FOR MIXING.

First, Fr. yellow, gum, cream tartar, white and blue vitriol, sugar of lead and alum. Bark to be used same as No 1. Boil in one gallon of water.

DIRECTIONS.

With a sponge or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is *thoroughly saturated*. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

To Make a Hard Finish.

Wet as above, when dry apply a coat of gum with a flat varnish brush, brush very lightly on a soft power brush to lay the gum on even; do not press the shoe hard against the brush, as it will have a tendency to darken it; let dry, then polish on machine or medium stiff brush.

No. 5.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White oak, shaded to cream. For hemlock leather. 5 gall.

Fr. Yellow	2	lbs.
Cream Tartar	2	"
White Vitriol	2	"
Blue Vitriol	2	"
Oxalic Acid	1	"
Globular Salts	1	"
Dextrine	¼	"
Gum Tragacanth Heavy	2	qts.

DIRECTIONS FOR MIXING.

First gum, Fr. yellow, cream tartar, white vitrol, blue vitrol, oxalic acid, globular salts and dextrine; boil three hours.

Stain to be applied same as No. 3.

No. 7.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: pure white. 20 gallons.

Fr. yellow	8 lbs.
China Clay	8 "
White Vitrol	8 "
Blue Vitrol	8 "
Cream tartar	5 "
Oxalic Acid	3½ "
Gum Tragacanth (thin)	8 qts.

Directions for mixing same as No. 5.

Stain applied same as No. 3.

This is a very heavy stain made especially to cover poor leather. If worked in with a very stiff hand brush, there are no reasonable imperfections that this stain will not cover. It is subject to a high gloss. It can be used as a sediment hard finish.

No. 9.

Sediment, Dry Out, Dry Brush or Burnish Stain.

White oak. For oak or Union leather. 4 gallons.

White Vitrol	1 lb.
Epsom Salts	1 "
Hyposulphate of Soda	1 "
Oxalic Acid	¼ "
Cream Tartar	½ "
Pipe Clay	4 "
French Gelatine	40 sheets.
Gum Tragacanth (very thin)	1 qt.

DIRECTIONS FOR MIXING.

First, pipe clay, gum, cream tartar, white vitrol, oxalic acid, Epsom salts. Boil two

hours. Dissolve gelatine before adding to the stain. Add Hyphosulphate of soda the last thing.

DIRECTIONS.

With a sponge, or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is *thoroughly saturated*. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

To Make a Hard Finish.

Wet as above, when dry, apply a coat of gum with a flat varnish brush, brush very lightly on a soft power brush to lay the gum on even, do not press the shoe hard against the brush as it will have a tendency to darken it; let dry, then polish on machine or medium stiff brush.

No. 11.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White oak. For hemlock, oak or Union leather. 10 gallons.

White Vitrol	. . . .	2½ lbs.
French Yellow	. . . .	½ "

Cream Tartar	1	"
Oxalic Acid	¾	"
Pipe Clay	5	"
French Gelatine	50	sheets.
Gum Tragacanth (thin)	2½	qts.

Directions for mixing same as No. 9.

DIRECTIONS.

With a sponge, or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is thoroughly saturated. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or haud brush. Bone or burnish with hot iron. Two coats will improve the looks; the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

To make a hard finish see No. 9.

This stain has a good body, and readily covers imperfections. It fills the leather, yet shows the fibres plainly. Hemlock leather finished with this stain resembles Union finished with acid, and brushed to a polish. It is subject to a high gloss with hot iron or Briggs' polishing machine.

No. 13.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White oak. For hemlock, Union or oak leather. 10 gallons.

Blue Vitrol	1½	lbs.

White Vitrol	2½	"
Cream Tartar	2½	"
French Yellow	2½	"
Oxalic Acid	1¼	"
Gum Tragacanth (thin)	4	qts.

Directions for mixing see No. 9.

Apply stain same as No. 9.

To make a hard finish see No. 9.

This stain is what is generally called oak or white, and is a good covering stain. Hemlock leather finished with No. 13 is a good imitation of oak, if used as a hard finish stain, it resembles oak or Union finished with acid and gum.

No. 15.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White oak. For hemlock, oak or Union leather. 10 gallons.

Blue Vitrol	2	lbs.
White Vitrol	3	"
French Yellow	2½	"
Cream Tartar	2	"
Oxalic Acid	1¼	"
Gum Tragacanth (medium)	3	qts.

Directions for mixing see No. 9.

Apply stain same as No. 11.

No. 17.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White. For hemlock or Union leather. 5 gallons.

White Vitrol	2	lbs.
Blue Vitrol	1¼	"
Cream Tartar	1	"
Oxalic Acid	1	"
French Yellow	½	"
Pipe Clay	5	"
French Gelatine	40	sheets.
Gum Tragacanth (thin)	3	pints.

Directions for mixing same as No. 3.

Apply same as No. 11.

No. 19.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: Oak, shaded to cream. For hemlock, oak or Union leather. 10 gallons.

White Vitrol	2½	lbs.
French Yellow	2½	"
Cream Tartar	2½	"
Terra Alta	2½	"
Pipe Clay	10	"
French Isinglass	25	sheets.
Gum Tragacanth	2½	qts.

Directions for mixing same as No. 3.

DIRECTIONS.

With a sponge, or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is thoroughly saturated. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the

looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

To make a hard finish see No. 9.

This stain works well into the leather, fills all coarse places, and covers all imperfections. It is subject to a high polish when dry by burnishing, boning or dry brushing. It works well as a hard finish stain. This stain can be smoothed off by power brush, known among finishers as Power Dry Out. Better results have been (or are) obtained by smoothing off all sediment stains with a hand brush.

No 21.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White oak. For hemlock, oak or Union leather. 8 gallons.

China Clay	5	lbs.
Tera Alba	6	"
French Yellow	3	"
White Vitrol	4	"
Blue Vitrol	3	"
French Gelatine	40	sheets.
Gum Tragacanth (medium)	2	qts.

Directions for mixing same as No. 3.

DIRECTIONS.

With a sponge, or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is thorough-

ly saturated. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

To make a hard finish see No. 9.

The ingredients of this stain have bleaching qualities. It also has a very heavy body, and will cover all reasonable imperfections. It can be used as a Sediment, Hard Finish, and works on English or any oak stock with as good results as Union. It is subject to a high gloss.

No. 23.

Sediment, Dry Out, Dry Brush or Burnish Stain.

Color: White. For oak or Union leather. 8 gallons.

Oxalic Acid	2 lbs.
Cream Tartar	1½ "
Blue Vitrol	2½ "
White Vitrol	1½ "
French Yellow	1½ "
Isinglass	15 sheets.
Gum Tragacanth	1 qt.

Directions for mixing see No. 9.

DIRECTIONS.

With a sponge, or varnish brush, soak the stain well into the leather; brush in well with a stiff hand brush until the leather is thor-

oughly saturated. Smooth off with a very soft hand brush, then let dry thoroughly. Dust off with a soft power or hand brush. Bone or burnish with hot iron. Two coats will improve the looks, the first coat simply soaked in well with a sponge, for twelve pairs, then make second application.

No. 24.
Sediment, Hard Finish Stain.

Color: Red. For hemlock, oak or Union leather. 5 gallons.

Venetian Red.	8	lbs.
Orange Chrome	2	"
French Yellow	1	"

DIRECTIONS FOR MIXING.

Wet all dry colors with vinegar, making a paste of the same. Add one ounce of oil of sassafras, one ounce of pure white glycerine. This should be ground through a paint mill, if not, let stand twenty-four hours. Take one quart of gum tragacanth to a gallon of water; boil hard until it is about the consistency of cream. Add to the paste and mix well together.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

No. 25.

Sediment, Hard Finish Stain.

Color: Orange light. For hemlock, oak or Union leather. 5 gallons.

Orange Chrome (medium) . .	8	lbs.
Venetian Red	2	"
French Yellow	2	"
Oil of Sassafras	1	oz.
Glycerine	1	"

Directions for mixing see No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This is a heavy body stain, made to cover poor hemlock leather, principally used on heavy Stoga work.

No. 27.

Sediment, Hard Finish Stain.

Color: Orange medium. For hemlock, oak or Union leather. 5 gallons.

Orange Chrome Dark . . .	8	lbs.
Light Venetian Red. . . .	4	"
French Yellow	1	"
Oil of Sassafras	1	oz.
Pure White Glycerine . . .	1	"

Directions for mixing see No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well;

brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This is one of the best covering light colored stains in use. Hemlock leather finished with this stain cannot be detected from Union or oak.

No. 29.

Sediment, Hard Finish Stain.

Color: Dark orange. For hemlock, oak or Union leather. 5 gallons.

Orange Chrome Dark	8	lbs.
Light Venetian Red	4	"
French Yellow	1	"
Orange Aniline	1	pt
Oil of Sassafras	1	oz.
Glycerine	1	"

Directions for mixing see No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This stain has all the qualities and is of the same nature as No. 27, medium, but is a few shades darker. Is used to a great extent on medium grade boots, through New England and the West.

No. 31.

Sediment, Hard Finish Stain.

Color: Red Jersey, or Brick Red. For hemlock, oak or Union leather. 5 gallons.

Brandon Red	4½	lbs.
Light Venetian Red	4½	"
Gum Tragacanth	2	qts.
Oil of Sassafras	1	oz.
Glycerine	4	"

Directions for mixing same as No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush; then smooth off with a very soft hand brush, let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This stain can be boned, ironed or polished on the Briggs' machine.

This stain, like the others of this class, works on all kinds of leather, leaving the surface fine and even in color. Works easy.

No. 33.

Sediment, Hard Finish Stain.

Color: Leather Brown. For hemlock, oak or Union leather. 5 gallons.

Brown Ochre	2	lbs.
India Red	6	"
Orange Chrome	1	"
Oil of Sassafras	1	oz.
Pure White Glycerine	1	"

Directions for mixing same as No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth.

This stain is of a dark leather color, will cover all kinds of hemlock as well as oak or Union, and resembles the very dark custom finish (that is, the grain of the leather coulted down without buffing). Like the other hard finish, sediment stains, it will stand very hard usage.

No. 35.
Sediment, Hard Finish Stain.

Color: Dark buff, shaded to red. For hemlock, oak or Union leather. 5 gallons.

Terra Alba	4	lbs.
French Yellow	3	"
Light Venetian Red	2½	"
Oil of Sassafras	1	oz.
Glycerine	1	"

Directions for mixing see No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

No. 37.

Sediment, Hard Finish Stain.

Color: Very light buff. For hemlock, oak or Union leather. 5 gallons.

Medium Chrome	4½	lbs.
French Yellow	2	"
Light Venetian Red . . .	2	"
Oil of Sassafras	1	oz.
Pure White Glycerine . . .	1	"

Directions for mixing same as No. 24.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This is a hard finish sediment stain, know to finishers as "Jersey." It covers all imperfections, fills coarse places, leaving a very clear and uniform finish. It is subject to a high polish with gum or Briggs' polishing machine.

No. 39.

Sediment, Hard Finish Stain.

Color: Chocolate. For hemlock, oak or Union leather.

Burnishing Ink	2	qts.
Edge Ink	2	"
Venetian Red	2	lbs.

Mix well together.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff hand brush, then smooth off with a very soft hand brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

This stain can be boned, ironed or polished on the Briggs' machine.

This stain is made specially to cover poor leather and give it the uniformity of the best of oak. It does not lay on the outside surface, but penetrates the leather, and the fine fibers so much desired are plainly to be seen. It is also subject to the highest possible polish.

No. 41.

Sediment, Hard Finish Stain.

Color: Buff. Hemlock, oak or Union leather. 10 gallons.

Medium Chrome	9	lbs.
French Yellow	4	"
Light Venetian Red	4	"
Gum Tragacanth (thin)	3	qts.

DIRECTIONS.

With a soft sponge soak the stain in well; brush first with a medium stiff brush, then smooth off with a very soft brush; let dry thoroughly; for a polish apply a coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

No. 43.
Quick Brush Stain.

Color: Orange. For hemlock, oak or Union leather.

Orange Aniline	2	oz.
Dissolved in Hot Water.		
Gum Tragacanth	1	gal.
Add a very little Oxalic Acid.		
Mix together; boil 15 minutes.		

DIRECTIONS.

Lay stain on even with flat brush or sponge, then brush to a polish on power brush. This can also be used as a dry out stain as follows: After applying stain, brush off even on power brush, then let dry and brush to a polish.

The quickness of the method is the principal feature in favor of stains of this class. This is one of the best shades produced by this method, works very easy and covers slight imperfections, leaving a hard and very high finish.

This can be used as a transparent stain by applying as follows:

DIRECTIONS.

Apply the stain very freely with a sponge or varnish brush. Brush very lightly with a soft power or hand brush to lay the stain on even.

Do not press the shoe too hard against the brush, as it will have a tendency to darken it.

Let dry thoroughly, then apply a light coat of the stain or gum and brush to a polish.

No. 45.

Quick Brush Stain.

For hemlock, oak or Union leather.

Color: Leather brown, light custom shade.

Gum Tragacanth (stiff)	3	pts.
Extract of Logwood	2	oz.
Salt	1	spoonful.

DIRECTIONS.

Lay stain on even with flat brush or sponge, then brush to a polish on power brush. This can also be used as a dry out stain as follows: after applying stain, brush off even on power brush, then let dry and brush to a polish.

To use as a transparent stain, apply as follows:

DIRECTIONS.

Apply the stain very freely with a sponge or varnish brush. Brush very lightly with a soft power or hand brush to lay the stain on even.

Do not press the shoe too hard against the brush, as it will have a tendency to darken it.

Let dry thoroughly, then apply a light coat of the stain or gum and brush to a polish.

No. 47.

Quick Brush Custom Stain.

Color: Leather color. For Hemlock

Aniline Red	1	oz.

Dissolved in 1 quart hot water.

Gum Tragacanth (medium)	3	qts.

Mix together; boil 15 minutes.

DIRECTIONS.

Work the stain well into the leather with a sponge or varnish brush. Lay the stain even by brushing very hard on power brush. Go through the case in this way, then take those stained first, apply a light coat of stain or gum and brush to a polish.

Generally one coat of stain applied as gum, and brushed out quickly is sufficient.

No. 49.

Quick Brush Custom Stain.

Color: Custom brown. For hemlock, oak or Union leather.

Aniline Brown . . . . 1 oz.
Dissolved in 1 quart hot water.
Gum Tragacanth . . . 1 gal.
Mix together; boil 15 minutes.

DIRECTIONS.

Work the stain well into the leather with a sponge or varnish brush. Lay the stain even by brushing very hard on power brush. Go through the case in this way, then take those stained first, apply a light coat of stain or gum and brush to a polish.

Generally one coat of stain applied as gum, and brushed out quick is sufficient.

No. 51.

Fancy Colored Stain.

Color: Brown. For hemlock, oak or Union leather.

Bismark Brown Aniline dissolved in Alcohol	8	oz.
Gum Tragacanth (very thin) .	1	qt.
Glycerine	4	oz.
Hot water	1	gal.

DIRECTIONS FOR FANCY STAINS.

With a soft sponge soak the stain in well; brush lightly with a very soft brush to lay the stain on even; let dry thoroughly; for a polish apply a thin coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

Fancy colored stains are used for shanks, bottoms and edges, same stain answering for all; for shanks, stripes, etc., apply with a brush same as for ink; brush off lightly with a soft brush; burnish with hot iron, same time as the ink stripe.

No. 53.

Fancy Colored Stain.

Color: Red. For hemlock, oak or Union leather.

Red Aniline dissolved in Alcohol .	8	oz.
Gum Tragacanth (very thin) .	1	qt.
Glycerine	4	oz.
Hot water	1	gal.

DIRECTIONS FOR FANCY STAINS.

With a soft sponge soak the stain in well; brush lightly with a very soft brush to lay the stain on even; let dry thoroughly; for a polish apply a thin coat of gum tragacanth, brushing

immediately with a soft power brush to a polish.

Fancy colored stains are used for shanks, bottoms and edges, same stain answering for all; for shanks, stripes, etc., apply with a brush same as for ink; brush off lightly with a soft brush; burnish with hot iron, same time as the ink stripe.

No. 55.
Fancy Colored Stain.

Color: Purple. For hemlock, oak or Union leather.

Purple Aniline dissolved in Alcohol .	6	oz.
Gum Tragacanth (very thin) .	1	qt.
Glycerine	4	oz.
Hot water	1	gal.

DIRECTIONS FOR FANCY STAINS.

With a soft sponge soak the stain in well; brush lightly with a very soft brush to lay the stain on even; let dry thoroughly; for a polish apply a thin coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

Fancy colored stains are used for shanks, bottoms and edges, same stain answering for all; for shanks, stripes, etc., apply with a brush same as for ink; brush off lightly with a soft brush; burnish with hot iron, same time as the ink stripe.

No. 57.
Fancy Colored Stain.

Color: Orange. For hemlock, oak or Union leather.

Orange Aniline dissolved in Alcohol	6	oz.
Gum Tragacanth (very thin)	1	pt.
Glycerine	4	oz.
Hot water	1	gal.

DIRECTIONS FOR FANCY STAINS.

With a soft sponge soak the stain in well; brush lightly with a very soft brush to lay the stain on even; let dry thoroughly; for a polish apply a thin coat of gum tragacanth, brushing immediately with a soft power brush to a polish.

Fancy colored stains are used for shanks, bottoms and edges, same stain answering for all; for shanks, stripes, etc., apply with a brush same as for ink; brush off lightly with a soft brush; burnish with hot iron, same time as the ink stripe.

No. 59.
Transparent Stain.

Color: White. For hemlock, oak or Union leather. 2 gallons.

White Vitrol	1	lb.
Oxalic Acid	¼	"
Cream Tartar	1	"
Blue Vitrol	12	oz.
Gum Arabic	3	"
Butler Antimony	1	"
Tartaric Acid	5	"
Epsom Salts	1	lb.
French Yellow	14	oz.

DIRECTIONS FOR MIXING.

Put in boiling water; let stand two weeks.

DIRECTIONS.

Apply the stain very freely with a sponge or varnish brush. Brush very lightly with a soft power or hand brush to lay the stain on even.

Do not press the shoe too hard against the brush, as it will have a tendency to darken it.

Let dry thoroughly, then apply a light coat of the stain or gum and brush to a polish.

This is a transparent stain, leaves no coating, yet covers imperfections in oak and Union leather. Goods finished with this have the appearance of oak leather filled and polished.

Ironed Light Acid.

Light acid. 1 gallon.

Castile Soap dissolved	1	qt.
Seamoss Farina dissolved	1	"
Coigret Glue	1	sheet.
Oxalic Acid	6	oz.
Gelatine	10	sheets.
Sulphate of Zinc	4	oz.
Gum Tragacanth	1	pt.

Brush acid bottom. 1 gallon.

Gum Tragacanth	1	qt.
Oxalic Acid	4	oz.
Sulphate of Zinc	4	"
Epsom Salts	1	lb.

Brush acid bottom. 2 quarts.

Gum Tragacanth	1	qt.
Oxalic Acid	1	oz.
Alum	1	"
Borax	1	"

Acid Bottom Oak Stock.

Add a small quantity of Dextrine and a few drops of sulphuric acid to your gum. The gum to be quite stiff. Apply the mixture to the bottom of the shoe, then brush dry and polish.

Shading Stains.

Anilines of proper shades may be used in coloring stains, omitting a part of the dry colors.

In making oak stain No. 9 dissolve in hot water the isinglass before adding it to the stain. Dissolve the Hypophosphate in water and add it the last.

Aniline colors dissolved in alcohol will give you better and clearer shades. A little acid may be used with good results.

Oak stain No. 11 may be shaded by adding 3 oz. of medium chrome, 3 oz. Venetian red, wet with vinegar. To make a cream color add more of the red and yellow.

Red, yellow and black added to oak stain will give you a pearl color.

Adding brown ochre to oak stain makes a very pretty shade.

Brandon red added to oak or Jersey makes a nice shade.

To darken Jersey stain No. 37 add more of the red, omitting part of the yellow revers and will be light.

Oak stain No. 9 can be darkened by the addition of 6½ oz. of French yellow. To make it a flesh color add 3½ oz. of light Venetian red.

Various Ingredients Used in Making a Brush or Iron Custom Bottom.

Redwood steeped in alcohol makes a very good red dye. Use a little acid.

Red sawnders treated in the same manner is also a very good dye.

A small quantity of bichromate of potash dissolved in water. Add a very small quantity of this to your gum and apply the mixture to the bottom of the boot or shoe; brush partially dry with a power brush, and then finish with a hot burnishing iron.

Orange aniline, extract of logwood, gum tragacanth and a small quantity of oxalic acid.

Orange and a small quantity of black aniline mixed with gum tragacanth (stiff); a little oxalic acid.

Brown aniline, gum tragacanth, a little acid.

Orange aniline with a small quantity of picric acid added to the gum. The aniline and picric acid to be first dissolved separately in water; care to be used in adding the acid to insure good results, as an excess of acid will precipitate the aniline.

All the following ingredients may be used in finishing the bottoms of boots and shoes:

Pipe Clay,

Terra Alba,

French Chalk,
White Lead,
Flake White,
Whiting,
Sulphate of Baryta,
French Yellow,
Blue Vitrol,
White Vitrol,
Oxalic Acid,
Tartaric Acid,
Muriatic Acid,
Sulphuric Acid,
Oil of Vitrol,
Gum Tragacanth,
Gum Arabic,
Animal Glue,
Fish Glue,
Dextrine,
Borax,
Copperas,
Cream Tartar,
Glawber Salts,
Epsom Salts,
Sal. Soda,
Logwood Extract
Bichromate of Potash,
Alum,
Tin Crystals,
Quercitron,
Picric Acid,
Logwood Extracts

Fustic Extracts,
Brown Ochre,
Orange Chrome,
Burnt Umber,
Vermilion,
Carmine,
Chrome Yellow,
Chrome Green,
Castile Soap,
Sour Beer,
Butter of Antimony,
Vinegar,
Red Saundress,
Mars Yellow,
Oak Bark Extract,
Wood Alcohol,
Sumac,
Egg Albumen,
Oil of Sassafras,
Glycerine,
Bisulphate of Soda,
Nitrate of Iron,
French Gelatine,
Sea Moss,
Sea Moss Farina,
Magnesia,
Sugar of Lead,
India Red,
Brandon Red,
Venetian Red,
Mars Red,

Aniline Red,
Redwood.

Bleach.

To remove water stains.

A little bisulphate of soda and a little acid in clear cold water. With a sponge or varnish brush soak well into the leather; brush in well with a stiff hand brush until the leather is thoroughly saturated. Smooth off with a soft hand brush.

Rubber or Channel Cement.

Virgin or native India rubber. Cut into small pieces. A bottle is filled with this to about one-tenth of its capacity. Benzine is then poured on until about three parts full. It is then kept until thoroughly dissolved and of a thick consistency. To thicken or thin add either material.

A Good Edge Wax.

No. 7 Gum Carnawba	9	oz.
Good Cericine	7	"

Add a little cotton-seed oil. Melt by hot water same as glue, a kettle within a kettle. Mould when partly cool.

A Preparation to Use in Burnishing Ink.

To prevent the iron from scratching.

Pulverized Pumice-stone	8	oz.
Crocus	2	"
Prussian Blue	1	"

Mix well together and use in small quantities.

Preparation to Use in Burnishing Ink.

Logwood	1	lb.
Nitrate of Iron	8	oz.
Glycerine	3	"

Makes 1 gallon. Use one-half pint to a gallon of blacking.

To insure a black top lift use a little nitrate of iron in the blacking that you use on such.

No. 1.

TABLE FOR COLORS AND SHADES.

STONE COLOR.

White lead a little burnt, or raw umber.

GRAY STONE.

White lead and a little black.

SKY BLUE.

White and Prussian blue.

FAWN COLOR.

White stone ochre; a little vermilion.

LEMON COLOR.

White and chrome yellow.

PEACH COLOR.

White, with either vermilion, India red, purple, brown or burnt umber.

PEARL.

Blue, with lead color.

LEAD COLOR.

Lampblack with white.

BUFF.

Yellow ochre and white.

FRENCH WHITE.

White, tinted with purple.

BRIGHT GREEN.

Paris green with white.

DARK GREEN.

Black, with chrome green.

PEA GREEN.

Chrome green with white.

BRILLIANT GREEN.

Emerald green with white.

ORANGE.

Vermilion with chrome yellow.

STRAW COLOR.

Chrome yellow with white lead.

CREAM.

White tinted with red and yellow.

OLIVE.

Chrome yellow, blue, black and red.

FRENCH GRAY.

White tinted with black and purple.

ASHES OF ROSES.

White with tints of black and purple.

ROSE.

Lake with white.

PINK.

Carmine with white.

PURPLE.

Carmine with blue.

PEARL GRAY.

White, blue and black.

VERMILION.

Carmine and yellow.

LAVENDER.

Carmine, ultramarine and white.

UMBER.

White, yellow, red and black.

BROWN.

Made with red and black.

BRIGHT BROWN.

Carmine, yellow and black.

CHESTNUT.

White and brown.

DRAB.

Umber and white.

CHOCOLATE.

Yellow and brown.

FLESH COLOR.

Carmine and straw.

SILVER GRAY.

Lampblack with indigo.

GOLD COLOR.

Chrome yellow, a little vermilion and white.

OLIVE GREEN.

Raw umber, Prussian blue.

Points.

All dry colors to be wet up with vinegar. See that the chrome is made very fine.

Gum used in stains to be thoroughly dissolved and made very fine.

In making stains use hot water or steam. Steam is the best.

Use a little oil of sassafras in your stains to disguise the odor of the vinegar. Add the oil to the dry colors.

Use the best of chemicals, for they are the cheapest and give you the best results.

To prevent fermentation in your gum use salicylic acid in small quantities.

A Good Polish or Slicker.

No. 1.

One package of sea moss farina dissolved in three quarts of hot water; same amount of gum tragacanth. Mix well together. Add a little oxalic acid.

No 2.

Shave a small quantity of castile soap and dissolve in hot water. Add to gum tragacanth. Mix well.

No. 3.

Sea moss, gum arabic and gum tragacanth

In dissolving gum tragacanth use ¼ lb. gum dry to a gallon of water. Stir thoroughly two or three times each day.

To make enamel stain in various shades use white lead for white. In Jersey or oak stain use china clay or terra alba.

A word about the speed of brushes.

For Jersey Bottoms.

The speed of brush should be about ten hundred revolutions to the minute.

For White or Oak Bottom.

The speed should be from ten to twelve hundred revolutions to the minute.

For Red or Custom.

The speed should be about fourteen hundred revolutions to the minute.

End Brush for Brush and Top Lift.

Should be about twelve hundred revolutions to the minute.

It is a good idea to have the same size shaft for all of your brushes, as you can change a brush that you have used for a white bottom after it has got worn down where it is too stiff and use it for a red or custom bottom on stoga work.

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